

# Work Order ID 58098

April 23, 2010 7:09:43 AM



Page 1

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 4/23/10 Start Qty: 14.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4091

A

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

10.5.02

14

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA920 AND DWG  
FOLIO REV: 1/1  
DWG REV: 1/1

0.00

10.5.02

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58098

April 23, 2010 7:09:43 AM



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Item ID:	D4091-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Lug					
Start Date:	4/23/10	Start Qty:	14.00		Cust Item ID:	
Required Date:	4/30/10	Req'd Qty:	14.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00	<i>10.5.02</i>			<i>14</i>			
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>SP 10/05/03</i>			<i>14</i>	<i>Ø</i>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<i>(14)</i>	<i>BR 10-5-3.</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58098

April 23, 2010 7:09:44 AM



Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 4/23/10

Start Qty: 14.00



Cust Item ID:

Required Date: 4/30/10

Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

1114207  
START: 7:30am  
TEMP: 320°F  
FIN: 8:00am

0.00

=> JWS 10/05/04

14

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

(14)

10-5-4

170



Packaging

Packaging

Identify as per dwg & Stock Location: 460

0.00

Memo

0.00

10-5-4 (14) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 58098

April 23, 2010 7:09:44 AM



Page 4

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 4/23/10 Start Qty: 14.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/05 *[Signature]*

*PS 10-5-04*  
*(14)*

# Picklist Print

April 23, 2010 7:09:42 AM

Page 1

Work Order ID: 58098



Parent Item: D4091-1



Parent Item Name: Mounting Lug

Start Date: 4/23/10

Required Date: 4/30/10

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Start Qty: 14.00

Required Qty: 14.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	517.9499	1.8436			
-------	--	--------------	----	--	--	-----	---	----------	--------	--	--	--



Lug Extrusion



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT06

517.9499

43722

180

45800

337.9499

*[Handwritten signature and scribbles over the bottom section of the page]*

*[Handwritten date 10-3-11 and circled number 1.6910]*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	58098
Description: D4091-1 MOUNTING LOG		Part Number:	D4091-1
Inspection Dwg:	Rev:	Page 1 of 1	

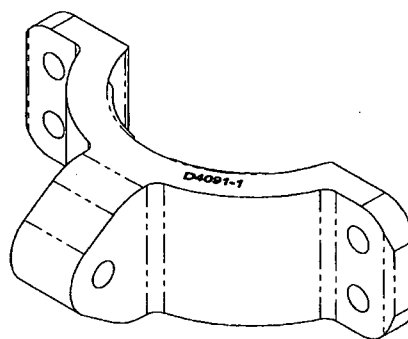
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	+/- .030	4.455	/			
1.38	+/- .030	1.381	/			
.27	+/- .030	.27	/			
.293	+/- .010	.291	/			
R1.20	+/- .03	R1.2	/			
.735	+/- .010	.725	/			
.375	+/- .010	.375	/			
3.700	+/- .010	3.700	/			
.257	+ .006 - .001	.256	/			
.625	+/- .010	.625	/			
.375	+/- .010	.375	/			
2.310	+/- .010	2.310	/			
1.91	+/- .030	1.910	/			
1.63	+/- .030	1.63	/			
35°	+/- 1/2°	35°	/			
.257	+ .006 - .001	.257	/			
.69	+/- .030	.69	/			
R.40	+/- .030	R.40	/			

Measured by: <i>ML</i>	Audited by: <i>SE</i>	Prototype Approval:	N/A
Date: 10.5.02	Date: 10/05/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D4091-1 MOUNTING LUG**

*W/C 58098*

**RELEASED**  
2010-04-29  
*W/C*

**NOTES:**

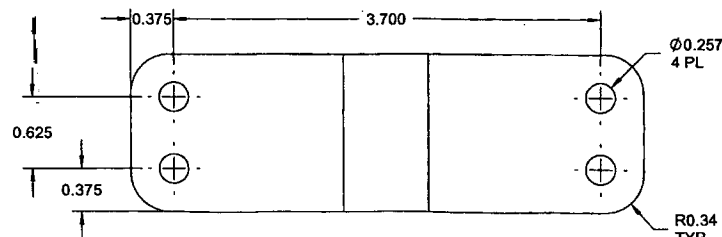
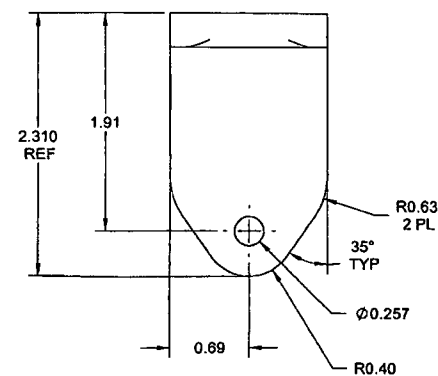
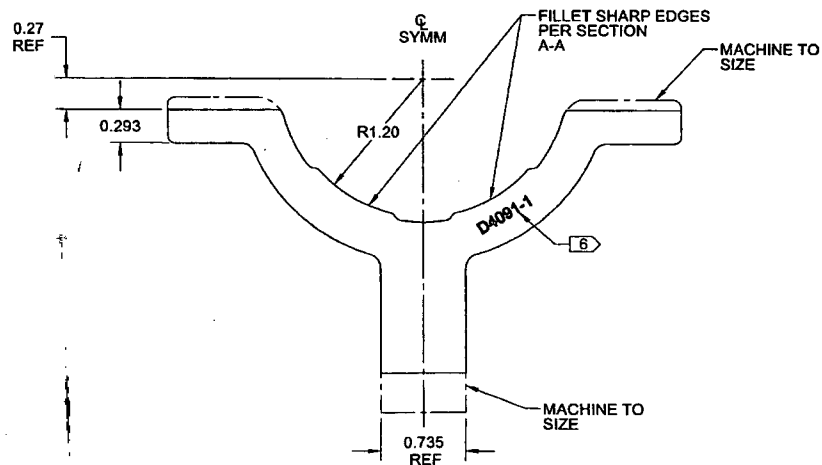
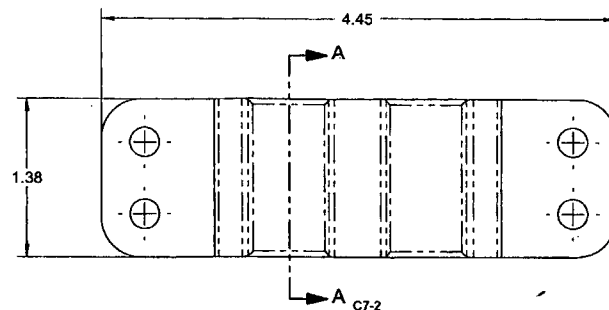
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS  
OF 0.015  $\pm$  0.005
- 7) WEIGHT: 0.31 lbs

A		NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION		BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	CP				
CHECKED		DRAWING NO.	D4091	REV. A	SHEET 1 OF 2
MFG. APPR.		TITLE	MOUNTING LUG	SCALE	NTS
APPROVED		DATE 10.03.29			
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



R0.03-R0.07  
TYP AROUND PAD

**SECTION A-A** CS-2



**D4091-1 MOUNTING LUG**

**RELEASED**  
2010-04-20  
AND

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4091</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG</b>	NTS
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